

Work Order ID 77271-1

Wednesday, November 30, 2011 3:27:41 PM

77271

Page 1

Item ID: D3687-1

Revision ID:

Item Name: MOUNT

Start Date: 11/30/2011 Start Qty: 6.00

Required Date: 12/23/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: *MF*

QC:

Date: 11-11-30 Tooling:

Date: SPC (Y/N):

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr Revision Nbr

D3687 Rev C

100

0.00

100

Outsource1

Outsource process - Heat Treat

Memo

Send M174B3937X4750 For heat treating
to CONDITION H-900(to become M174PHH900B3937X4750)
FTU IN EXCESS OF 190 KSI
FTU IN EXCESS OF 170 KSI

CERTIFICATE IS REQUIRED

0.00

105

0.00

105

Outsource5

Outsource process - Machining

Memo

Issue P/O: 15623
Machine as per Dwg D3687
Possible Supplier: Globus Precision
Conformity sheet required

0.00

*material already
to H900*

CL 11/12/11

CL 11/12/11 (6)

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Item ID: D3687-1

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Required Date: 12/23/2011 Req'd Qty: 6.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Tooling:

Date:

Run Start ***NR1***

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

110

110

Packaging

Packaging

Operation
Description

Receive & Inspect for Damage & Mat'l Certs

Set Up/
Run Hours

0.00

Memo

Ensure certificate of conformity is attached

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

11/30/11 *(1)*

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

INSPECT HOLE ALIGNMENT USING DT9707 JIG

0.00

5/26/13

(7)

124

124

Purchasing

Purchasing

0.00

Memo

Issue P/O FOR LIQUID PENETRATION

P/O #: *16046*

0.00

Certificate of conformity is required

CY 12/01/31 *(1)*

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Wednesday, November 30, 2011 3:27:41 PM

Item ID: D3687-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: MOUNT

Start Date: 11/30/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/23/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

125

Receive & Inspect for Damage & Mat'l Certs

0.00

125

Packaging

Memo

0.00

Packaging

ENSURE NDT RESULT IS ATTACH

12/4/31

126

QC5- Inspect part completeness to step on W/O

0.00

126

QC

Memo

0.00

Quality Control

12/4/31

127

QC6- Inspect dimensions to drawing

0.00

127

QC

Memo

0.00

Quality Control

DIMENSIONAL CHECK.
ENSURE THAT BOLT HOLES ARE CORRECT SIZE

8.12/13/31
Dre & sks
12/20

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Wednesday, November 30, 2011 3:27:41 PM

Item ID: D3687-1

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Item Name: MOUNT

Start Date: 11/30/2011 Start Qty: 6.00

Required Date: 12/23/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

Identify as per dwg & Stock Location: *Get*

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

12/1/31
LMF
12-01-31

Picklist Print

Wednesday, November 30, 2011 3:27:40 P

Page 1

Work Order ID: 77271
Parent Item: D3687-1
Parent Item Name: MOUNT

Start Date: 11/30/2011

Required Date: 12/23/2011

Start Qty: 6.00

Required Qty: 6.00

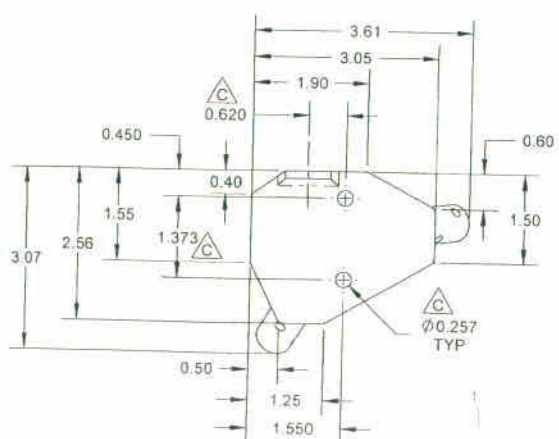
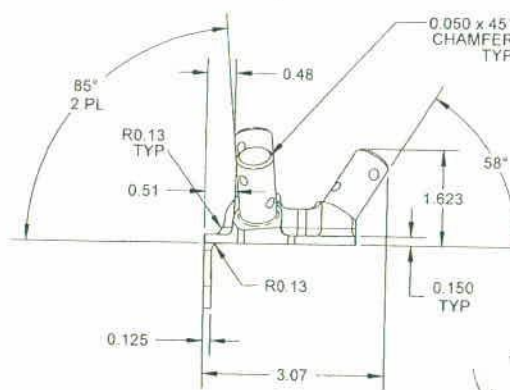
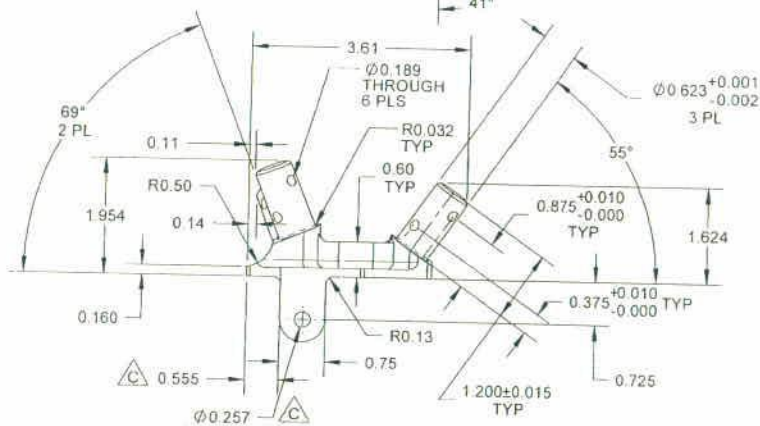
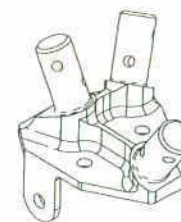
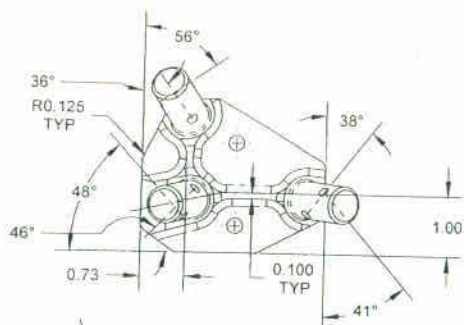
Comments: IPP Rev:A New Issue 08-01-15 JLM Verified By:EC
IPP Rev:B Added Contion H-900 JLM Verified By:DD IPP REV C: ADDED QC6
10.09.09 JLM VERIFIED BY DD
IPP REV D:ADDED DT9707 INSPECTION JIG 11-01-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH- H900B3.937X4.750 17-4SS Bar H900-3.937x4.750		Purchased	No			100	f	17.0000	0.33333	1.99998			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT005		17							
				112374		17							
D3687-1P MOUNT		Purchased	No			105	Each	0.0000	1	6			

02/11/2012

1.999

11/30/11



D3687-1 MOUNT

- NOTES
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.81 lb
 - 8) LPI PER QSI 038 4 1.1 (ASTM E1417 LEVEL 2)

RELEASED
2009-09-22

C	0.555 WAS 0.50 (ZN B8-1); 1.373 WAS 1.375 (ZN A8-1, A8-2); ADD 0.620 (ZN B7-1) PER NCR09-084; UPDATE NOTE 8 TO REF QSI (ZN A6-1, B3-2). Ø0.257 WAS Ø0.250 (ZN A6-1, B7-1, B7-2)	RF	09.08.26
B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R0.032 WAS R0.015 (ZN C7-1 & C7-2); REFORMATTED TO CURRENT DWG STANDARDS	RF	06.11.24
A	NEW ISSUE	RF	08.03.12
REV	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	GP		
MFG. APPR	GP		
APPROVED	GP		
DE APPR	GP		
DATE	09.08.26		

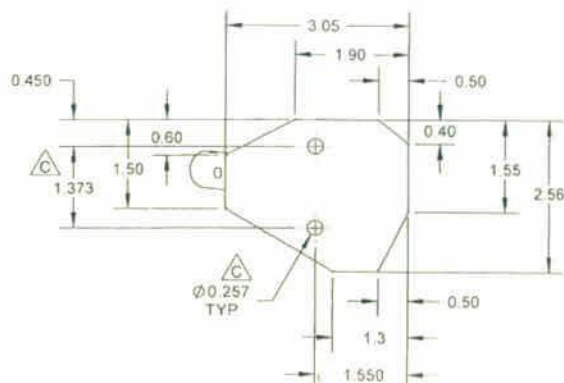
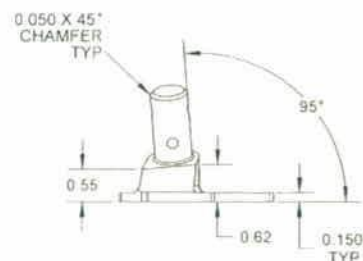
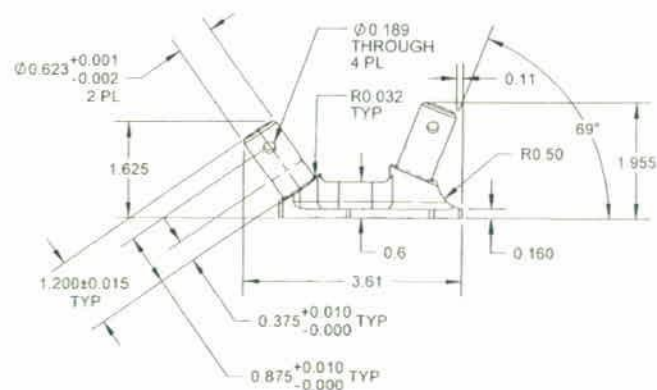
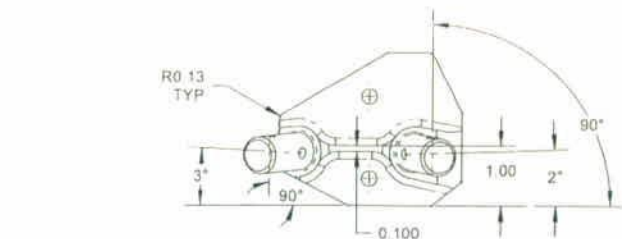
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3687**

TITLE **MOUNT**

REV. C
SHEET 1 OF 2
SCALE
NTS

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D3687-3 MOUNT

NOTES

- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.64 lb
- 8) LPI PER QSI 038 4 1.1 (ASTM E1417 LEVEL 2)



RELEASED
2009-09-22
MP

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG APPR	RF	D3687	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR	RF	MOUNT	NTS
DATE	09.08.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION OR COMMUNICATION TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15623

Purchase Order Date 12/06/11

PO Print Date 12/08/11

Page Number 1 of 1

Order From :

VC-GLO001

ARCHER PRECISION INC.
36 COLONNADE RD. N.
NEPEAN, ON K2E 7J6
CA

Contact Name

Vendor Phone 613 226 1579

Vendor Fax 613 226 1719

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3687-1P	MOUNT	1/17/12 Yes	6.00 Each	Yours ppd	\$400.0000	\$2,400.00

Special Inst: MACHINE AS PER DWG D3687 REV: C
B77271

PO Total: \$2,400.00

Change Nbr: 2

Change Date: 12/08/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



1393 Major Road
Orleans, Ontario
K1E 1H3

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

Po Number	Part Number	Quantities
15623	D3687-1P	1

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 15625 issued by Dart Aerospace Inc.

Alex Mazerolle
President
Archer Precision Inc.
1393 Major Road,
Orleans Ontario
K1E 1H3



1393 Major Road
Orleans, ON
K1E 1H3

Phone # 613-899-2405

Packing Slip

Date	Invoice #
1/26/2012	36

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
	1/26/2012			

Qty	Item Code	Description
1	Sales	D3687-1P Mount HST (ON) on sales 8/12/12/12



LIQUID PENETRANT TEST REPORT

P- 14905

PAGE 1 OF 1

CLIENT Dart Aerospace DATE January 30, 2012 TIME AM ☒ PM ☐
ATTENTION Lincoln ACUREN JOB NO. 188-12-00022
ADDRESS 1270 ABEL PERIN ST POWO NO. ---
Waukegan, IL WORK LOCATION Line
ACCEPTANCE STD. ASME 1917/AS-033 REV./DATE Jan 5
PROJECT E.P.I. on Disturbed Part C
ITEM(S) EXAMINED 4 CROSS RIBS

JOB DESCRIPTION --- PROCEDURE NO. LT-1002 REV./DATE Jan 5 TECHNIQUE NO. LT-1042 REV./DATE Jan 5
PART NO. --- MATERIAL 5052 ALUMINUM THICKNESS 0.040 IN.
SCOPE NET FLUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT ON BOTH EXTERIOR SURFACE

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☐ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND WASH 4 PLUS BLACK LIGHT S/N 10487 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT --- MINIMUM DWELL TIME 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER --- MINIMUM DRY TIME > 10 MIN. OTHER L43.01
DEVELOPER --- MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1078866 CAL DUE DATE Jan 27
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/ 50°F ☒ 10°C/ 50°F TO 52°C/ 125°F ☐ > 52°C/ 125°F

RESULTS- ☐ METRIC ☐ IMPERIAL

1 - W.C. 78466 - Mount. ✓
1 - W.C. 78466 - CROSS RIBS ✓
1 - W.C. 78465 - CROSS RIBS ✓
1 - W.C. 78470 - CROSS RIBS ✓
1 - W.C. 78467 - CROSS RIBS ✓
X INDICATIONS TO BE CURED.
8/26/13

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and explanations reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representative of accuracy. Acuren Group Inc. is not assuming any responsibility of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performance of services provided by Acuren Group Inc. the degree, care and skill ordinarily used by similarly situated persons performing such services in the same or similar locality. No other warranty expressed or implied, written or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Andrew Sholov SIGNATURE Andrew Sholov DTR # E-C-38CS
TECHNICIAN (SIGNATURE) Mike Fisher REPORT REVIEWED BY: ---
NAME (PRINT): Mike Fisher NAME INITIALS
1st TECHNICIAN 2nd TECHNICIAN
CGSB LEVEL I SNT LEVEL I CGSB LEVEL --- SNT LEVEL ---
CGSB REG. NO. 06001 CGSB REG. NO. ---

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CANARY - OFFICE COPY

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GOLD - OFFICE COPY